

Work Order ID 65206

January 10, 2011 7:40:38 AM



Page 1

Item ID:	D3648-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Driveshaft Tunnel Assembly					
Start Date:	1/10/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/21/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/01/10</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3648	Rev B								
100	Pick Kit	0.00							
	Packaging	0.00							
	Packaging								
110	Small Fab	0.00							
	Small Fab	0.00							
	Small Fab								
	1-Assemble as per dwg D3648 2-Seal mating surface and all gaps as per dwg D3648 with Proseal 700 fire wall sealant batch: <u>KL6573</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Quality Control								

SA 11/01/10

SB 11/01/10

Sublet

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65206

January 10, 2011 7:40:38 AM



Page 2

Item ID: D3648-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Driveshaft Tunnel Assembly

Start Date: 1/10/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

RPP
62543

0.00

Packaging

11/21/18

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18
MF
11-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 10, 2011 7:40:37 AM

Page 1

Work Order ID: 65206

Parent Item: D3648-041

Parent Item Name: Driveshaft Tunnel Assembly

Start Date: 1/10/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-10-03 EC verified by: DD
IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC
IPP Rev:C ECN1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10	NAS1149C0363 R	Purchased	No			100	Each	0.0000	40	40			
----------	-------------------	-----------	----	--	--	-----	------	--------	----	----	--	--	--



WASHER

AN3C3A



Bolt

Purchased

No

110

Each

381.0000

40

40

Location

Loc Qty

Loc Code

ST350

381

115159

81

115936

100

116081

200

D3649-041



Tunnel Bottom Panel Assembly

Manufactured

No

110

Each

5.0000

1

1

Location

Loc Qty

Loc Code

ST190

5

52638

5

D3650-041



Tunnel Top Panel Assembly

Manufactured

No

110

Each

0.0000

1

1

D3651-041



Aft Base Assembly

Manufactured

No

110

Each

0.0000

1

1

W 113889



SB 11/21/13



SB 11/01/13

40

SB 11/01/13

①

B 65211



SB 11/01/13

①

B 65211



SB 11/01/13

①

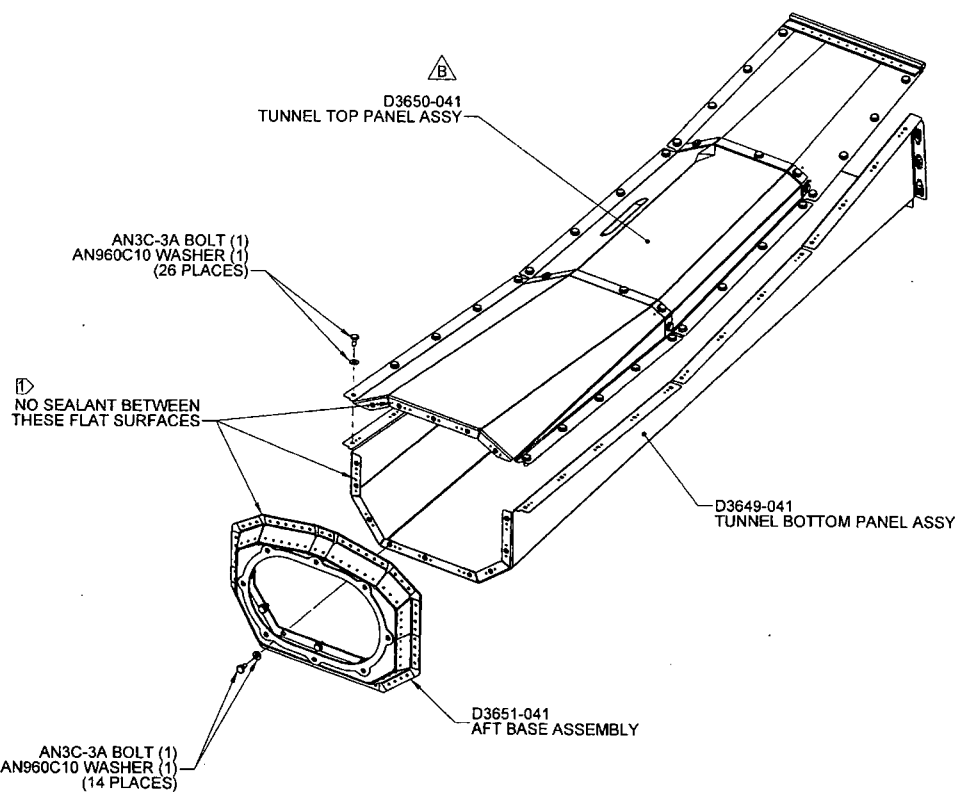
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

NOTES:

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED
08.01.07

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3648	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DRIVE SHAFT TUNNEL ASSY	1:5
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 65306

CZ 11/01/10